<b>Work Order ID 6</b> Wednesday, December 01, .			· .					-				Page 1
tem ID: D4016-1 Revision ID: tem Name: Hinge Half,	Base		Accept						Setup	Start Stop		
Start Date: 12/1/2010 Required Date: 12/8/2010 Reference:					Cust Item I Customer:	D:	*					
Approvals: Process F	Plan:	Date://///2-/	Tooling: SPC (Y/I	N):	· Da	nte:	^ 	<i>b</i>	Run	Start Stop		
Sequence ID/ Work Center ID	Operation Description	2	Set U <sub>l</sub> Run I		Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr R D4016 A	evision Nbr											
Bandsaw Jeaspa Bandsaw	Cut blanks as per folio	K 1.00" LONG	0.00	J.A	10/12/21	· •		9		Ø		
HAAS 1 HAAS CNC vertical machine #1	FOLIO REV		0.00 0.00 ND DWG	B.a	10/12/21	H.		<u> </u>	mana sa magana	φ		
	DWG REV: DEBURR	<u> </u>		•	, , , , , , , , , , , , , ,						•	•

W/O:			N	ORK ORDE	R CHANGE	S					
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No:		PAR #:	Fault Ca	tegory:		NCR: Yes	s No <b>DC</b>	)A:	Date: _		
Resolution:			Disposit	ion: 🛌		QA: N/C	Closed: _		Date: _		
NCR:			WORK OR	DER NON-C	ONFORMA	NCE (NC	R)				
DATE	STEP	Description of NC	Description of NC Corrective			ver			Approval	Approval	
DATE	SIEP	Section A			<b>Description</b> Chief Eng				Chief Eng	QC Inspecto	
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				1							
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			7					<del></del>			

Packaging

Packaging

Memo

Page 2

Wednesday, December 01, 2010 10:07:48 A Item ID: D4016-1 Accept Setup Start **Revision ID:** Stop Item Name: Hinge Half, Base **Start Date:** 12/1/2010 Start Oty: 9.00 **Cust Item ID:** Req'd Qty: 9.00 **Required Date: 12/8/2010 Customer:** Reference: Start Run Approvals: Process Plan: \_\_\_\_ Date: \_\_\_ Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description **Run Hours Qty** Code **Qty** Number Stamp 120 QC2- Inspect parts off machine FAI/FAIB 0.00 DA 10/12/21 0.00 Memo Quality Control 0.00 1 10/12/21 130 QC8- Inspect parts - second check 0.00 Memo Quality Control 160 Identify as per dwg & Stock Location: 0.00

W/O:			WO	RK ORDER CHANG	ES				•
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	Jory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
	Resolution:		Disposition	1:	_ QA: N/C (	Closed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)			
	T	Description of NC		Corrective Action Sect	tion B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
								7	

#### Work Order ID 64264

Wednesday, December 01, 2010 10:07:48 A



Page 3

Item ID:

D4016-1

Accept

Setup Start



**Revision ID:** 

Item Name:

Hinge Half, Base

**Start Date:** 

Required Date: 12/8/2010

12/1/2010

Start Qty: 9.00

Req'd Qty: 9.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date: \_\_\_\_\_

Date:\_\_\_\_\_ Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Sequence ID/

Work Center ID

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/

**Run Hours** 

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

170

Quality Control

OC

Memo

0.00

0.00

CK 10/12/22

P/0-12-22

(9)

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W/O:			WC	RK ORDER CHANGE	S				τ
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Da	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	s No	DQA:	Date: _	
	Re	esolution:	Disposition	n:	QA: N/C	Closed	i:	Date: _	
NCR:			WORK ORDI	ER NON-CONFORMAI	NCE (NO	CR)			
		Description of NC		ı B		erification	Approval	Approval	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n &	Section C	Chief Eng	QC Inspector
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#### **Picklist Print**

Wednesday, December 01, 2010 10:07:52 AM

Work Order ID: 64264

Parent Item:

D4016-1

Parent Item Name: Hinge Halt, Base



Start Dat. 12/1/2010

Required Date: 12/8/2010

Page 1

Start Qty: 9.00

Required Qty: 9.00

Comments:

IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD

as per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.500X1.500		Purchased	No		*	100	f	3.0567	0.08	0.757895		<del></del>	· d

IPP Rev:B

304 bar 1.50 X1.50

Location Loc Oty Loc Code MAT54 3.05670868 ✓ 108381 2.398605 112752 0.65810368

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		W	ORK ORDER CHANG	GES					f	
STEP	PRO	OCEDURE CHA	NGE	Ву	C	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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	• • • • • • • • • • • • • • • • • • •	WORK ORD	ER NON-CONFORM	IANCE (N	CR)					
STED	Description of NC					Verific	l l	Approval	Approval	
JILF	Section A	Initial Chief Eng	Action Description Chief Eng			Section C		Chief Eng	QC Inspector	
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								1		
		:PAR #: Resolution:  STED Description of NC	PAR #: Fault Cate  Resolution: Disposition  WORK ORD  STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE  PAR #: Fault Category:  Resolution: Disposition:  WORK ORDER NON-CONFORM  STEP Description of NC Section A Corrective Action Section A Corrective Action Description	PAR #: Fault Category: NCR: Ye  Resolution: Disposition: QA: N/C  WORK ORDER NON-CONFORMANCE (Note that the content of NC Section A Section B Initial Action Description Signature (Note that the content of NC Section A Section B Initial Action Description Signature (Note that the content of NC Section A Section B Initial Action Description Signature (Note that the content of NC Section A Section B Initial Action Description Signature (Note that the content of NC Section A Section B Initial Action Description Signature (Note that the content of NC Section A Section B Initial Action Description Signature (Note that the content of NC Section A Section B Initial Action Description Signature (Note that the content of NC Section B Initial Action Description Signature (Note that the content of NC Section B Initial Action Description Signature (Note that the content of NC Section B Initial Action Description Signature (Note that the content of NC Section B Initial Action Description Initial Init	STEP PROCEDURE CHANGE  By Control of NC Corrective Action Section B Sign & Initial Action Description Sign & Sign	STEP PROCEDURE CHANGE By Date  :PAR #:Fault Category:NCR: Yes No DQA  Resolution:Disposition:QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr  : PAR #: Fault Category: NCR: Yes No DQA: Date: Partial Category: NCR: Yes No DQA: Date: NCR: Yes No DQA: Date: NCR: Yes No DQA: Date: Date: NCR: Yes No DQA: NCR: Yes No DQA: Date: NCR: Yes No DQA:	

DART AEROSPACE LTD	Work Order:	64764
Description: Hinge Half, Base	Part Number:	D4016-1
Inspection Dwg: D4016 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

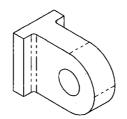
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.875	+/-0.010	0.880	V		Van	6A-01
0.25	+/-0.030	0.246	-		f.,	11
0.38	+0.030/-0.000	0.389	~		11	51
R0.03	+/-0.030	RO-030	✓		R-6	( ( )
0.13	+/-0.030	0.129	~		Vern	6A-01
0.88	+/-0.030	0.877	~		11	11
Ø0.257	+0.006/-0.001	Ø0.259	✓		11	1)
R0.38	+/-0.030	R6.375	~		R-6	ref.
0.500	+/-0.030	0.499	~		Vern	6A-01
0.75	+/-0.030	0.752	V		N	1/

Measureo by:	H.A	Audited by:	ント	Preliminary Approval:	
Date:	10/12/21	Date:	10/12/21	Date:	

Rev	Date	Change	Revised by	Approved
Α	10.06.07	New Issue	KJ dk	

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	GE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC	on of NC Corrective Action				cation	Approval	Approval
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Dat		ion C	Chief Eng	QC Inspector
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SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 44269



**D4016-3 HINGE HALF, LID** 



D4016-5 HINGE HALF, LIGHT LID

RELEASED 2010 -02- 16

Α	NEW IS	SUE		JPH	10.01.29				
REV.			DESCRIPTION	BY	DATE				
DESIG	٧.	AJS	DART AEROSPACE LTD						
DRAW	v.	AJS	HAWKESBURY, ONTARIO, CANADA						
CHECK	CHECKED (1)		DRAWING NO.	<del></del>	REV. A				
MFG, A	PPR.	7	D4016	SHEET 1 OF					
APPRO	VED	140.	TITLE		SCALE				
DE APF	DE APPR.		BASKET HINGE		NTS				
DATE	10.0	1.29	COPYRIGHT © 2010 BY DAI THIS DOCUMENT IS PRIMATE AND CONTRIBETIAL AND IS SU NOT TO BE USED FOR ANY PURPOSE OR COPED OR COM-	PPLED ON THE EXPRES	IS CONDITION THAT IT IS				

D4016-1 HINGE HALF, BASE

W/O:	}		WORK ORDER CHANGES									
DATE STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No:		PAR #:	Fault Category:			NCR: Yes No			o DQA: Date:			
-	R	PAR #:Fault Category: NCR: Yes No _DQA:	Disposition:			QA: N/C Closed:			Date:			
NCR:			WORK ORDE	R NON-CONFOR	RMANCE	(NCR)						
DATE	STEP	Description of NC	l			Ciam 9						
DAIL	SIEF	Section A			on		Secti	on C	Chief Eng	QC Inspector		
					i							
	1								1			

GRAIN DIRECTION

R0.03

0.563 -

0.50

0.63

0.13

0.250

R0.31 REF

> Ø0.257 THRU

0.875 0.25 0.38+0.03 R0.38 REF Ø0.257 THRU GRAIN 0.88 DIRECTION 0.50 0.13 R0.03 TYP 0.75

#### **D4016-1 HINGE HALF, BASE**

**D4016-3 HINGE HALF, LID D4016-5 HINGE HALF, LIGHT LID** 

wlo 64264

D

DESIGN	AJS	DART AEROSPA	CELTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA			
CHECKED	W	DRAWING NO.	REV /		
MFG. APPR.	7	D4016	SHEET 2 OF		
APPROVED	140	TITLE	SCAL		
DE APPR.		BASKET HINGE	NT		
DATE 10.0	1.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IN PRIMATE AND COMPRESTING AND GRUPPING ON THE EXPRESS CONDITION THAT IT!  NOT TO BE USED FOR ANY PURPOSE OF COMPECING COMPRIGHTS OF THE CONTROL OF			

NOTES: 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR, PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B

REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

2

Dart A	Aerosi	pace	Ltd
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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No:	\$ .	_ PAR #:	Fault Category: _		NCR: Yes No	DQA:	Date:	
	Resolution:		Disposition:	•	QA: N/C Closed	l:	Date:	

NCR:		W	ORK OR	DER NON-CONFORMANCE (NCF	<u>;)</u> .		
· · · · · · · · · · · · · · · · · · ·		Description of NC	,	Corrective Action Section B	Verification	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Section A	Initial Chief Eng	Action Description Sign & Date	Section C		
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